

Work Order ID 77661

Wednesday, December 14, 2011 10:49:36 A

Page 1

Item ID: D412-698-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/6/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-12-14 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

8/12/17

MLJ 12-1-17

(6)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/1/17 (6)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

8/12/17

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77661***77661***




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Wednesday, December 14, 2011 10:49:36 A

Item ID: D412-698-023 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Automatic Door Opener, LH/RH
Start Date: 12/14/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 1/6/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging	0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>10</u>								
	PPP Rev: <u>B</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/11/17  
12/11/18 
4ME
12-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, December 14, 2011 10:49:42 AM

Work Order ID: 77661

77661

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2011

Required Date: 1/6/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516L	NAS1149D0516J	Purchased	No			120	Each	0.0000	2	12			
*AN960.ID516I *									**	114757			
Washer													
D3552-11		Manufactured	No			120	Each	25.0000	1	6			
D3552-11									**				
Door Prop													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272		25							
				74984		10							
				76059		15				76059			
D3594-043		Manufactured	No			120	Each	15.0000	1	6			
D3594-043									**				
Floor Doubler Assembly, LH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST234B		15							
				76096		15				76096			
D3594-044		Manufactured	No			120	Each	14.0000	1	6			
D3594-044									**				
Floor Doubler Assembly, RH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST234B		14							
				76097		14				76097			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 14, 2011 10:49:42 AM

Work Order ID: 77661

77661

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 12/14/2011

Required Date: 1/6/2012

Start Qty: 6.00

Required Qty: 6.00

D3594-5 Manufactured No

120 Each 21.0000

1 6

**

D3594-5

Door Doubler

Location

Loc Qty

Loc Code

ST234A

21

76098

21

120 Each 38.0000

2 12

**

D3622-1 Manufactured No

D3622-1

Ball Stud

Location

Loc Qty

Loc Code

ST070

38

76889

38

120 Each 1,417.000

2 12

**

MS20426AD4-4 Purchased No

MS20426AD4-4

Rivet

Location

Loc Qty

Loc Code

ST317

1417

116188

1417

120 Each 62.0000

1 6

**

MS21073L5 Purchased No

MS21073L5

nut plate

Location

Loc Qty

Loc Code

ST302

62

117395

62

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L*	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01